

Work Order ID 75226

75226

Page 1

October-19-11 11:09:54 AM

Item ID: D412-761-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Large Bubble Window, LH

Start Date: 19/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/10/11 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-761

Rev D

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-761-045 CHG001

5 u/12/11

MLJ 11-10-25
(1)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

11/10/25 \$

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5 u/12/11

(41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75226***75226***

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Item ID: D412-761-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Large Bubble Window, LH

Start Date: 19/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-045								
	Location: _____								
	PPP Rev: <u>11</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/12/1411/12/14ME
11-12-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October-19-11 11:09:58 AM

Page 1

Work Order ID: 75226

75226

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3704-3 Escutcheon		Manufactured	No			110	Each	4.0000	1	4			
D3704-3									**				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST075			4					
					56880			4					
D412-761-043 Modified Latch Mechanism, LH		Manufactured	No			110	Each	0.0000	1	1			
D412-761-043									**				
D3676-1 BUBBLE WINDOW		Manufactured	No			110	Each	0.0000	1	1			
D3676-1									**				
D3678-1 Placard		Manufactured	No			110	Each	12.0000	1	1			
D3678-1									**				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST074			12					
					46354			12					
D3678-3 Placard		Manufactured	No			110	Each	12.0000	1	1			
D3678-3									**				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST074			12					
					46355			12					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3700-1

Manufactured No

110

Each

3.0000

1

**

D3700-1

Inboard Window Doubler

Location

Loc Qty

Loc Code

ST075

3

54803

1

58839

2

D3700-3

Manufactured No

110

Each

3.0000

1

**

D3700-3

Outboard Window Doubler

Location

Loc Qty

Loc Code

ST076

3

54804

3

D3701-1

Manufactured No

110

Each

2.0000

1

**

D3701-1

Floor Doubler

Location

Loc Qty

Loc Code

ST077

2

56694

2

D3702-1

Manufactured No

110

Each

3.0000

1

**

D3702-1

Fwd Doubler

Location

Loc Qty

Loc Code

ST077

3

54806

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75226

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Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3703-1

Manufactured No

110

Each

8.0000

1

**

D3703-1

Aft Doubler

Location

Loc Qty

Loc Code

ST078

8

54807

1

56695

7

D3703-3

Manufactured No

110

Each

3.0000

1

**

D3703-3

Aft Corner Doubler

Location

Loc Qty

Loc Code

ST078

3

54808

3

D3703-5

Manufactured No

110

Each

10.0000

1

**

D3703-5

Aft Cap

Location

Loc Qty

Loc Code

ST075

10

54809

10

D3704-1

Manufactured No

110

Each

8.0000

1

**

D3704-1

ESCUTCHEON

Location

Loc Qty

Loc Code

ST075

8

56330

3

56696

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75226

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Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

S D3708-1
D3708-1
Angle

Manufactured No

110 Each 6.0000

**

Location

Loc Qty

Loc Code

ST086

6

56697

6

Manufactured No

110 Each 6.0000

**

S D3708-3
D3708-3
Angle

Location

Loc Qty

Loc Code

ST080

6

54813

1

56698

5

Manufactured No

110 Each 16.0000

**

S D3709-1
D3709-1
Angle

Location

Loc Qty

Loc Code

ST079

16

54814

9

56699

7

Manufactured No

110 Each 11.0000

**

S D3709-3
D3709-3
Angle

Location

Loc Qty

Loc Code

ST079

11

54815

3

56700

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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Work Order ID: 75226

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Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

S D3802-1 Manufactured No 110 f 601.8800 13.5 13.5
D3802-1
 Window Seal

**

Location	Loc Qty	Loc Code
ST412	601.88	
56881	601.88	

1- Cut one per dwg d3802-1-135

S DT9458 Manufactured No 110 Each 0.0000 1 1

DT9458

Cutting Template

S AN3-7A Purchased No 110 Each 211.0000 26 26

AN3-7A

Bolt

**

Location	Loc Qty	Loc Code
ST351	211	
117313	11	
117872	200	

S AN960JD10 NAS1149D0363J Purchased No 110 Each 0.0000 52 52

AN960JD10

Washer

**

13.5
 13
 13
 52 52 14x 16x
 M118077 M117505
 M118612 11/10/25 SP
 22x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Eric tel me the seal is ok sp 11/10/25					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

10,037.00

26

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

1037

117441

16

117885

87

118451

222

118927

712

ST516

6000

119017

6000

ST518

3000

119075

3000

MS24694-C5

Purchased

No

110

Each

66.0000

1

**

MS24694-C5

Screw

Location

Loc Qty

Loc Code

ST289

66

106815

66

MS24694-C13

Purchased

No

110

Each

43.0000

1

**

MS24694-C13

Screw

Location

Loc Qty

Loc Code

ST289

43

108558

43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

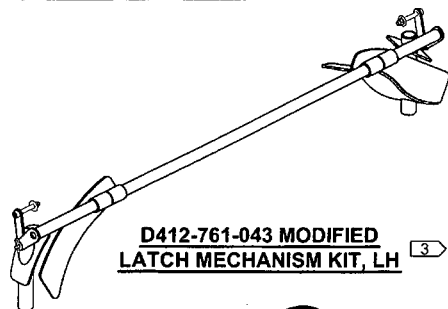
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

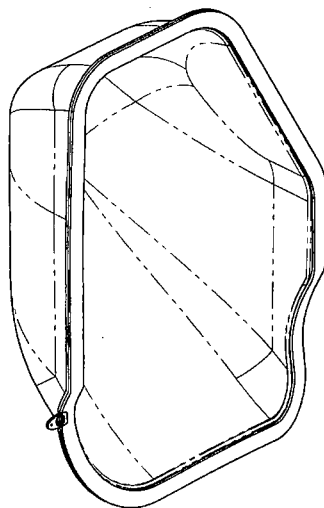
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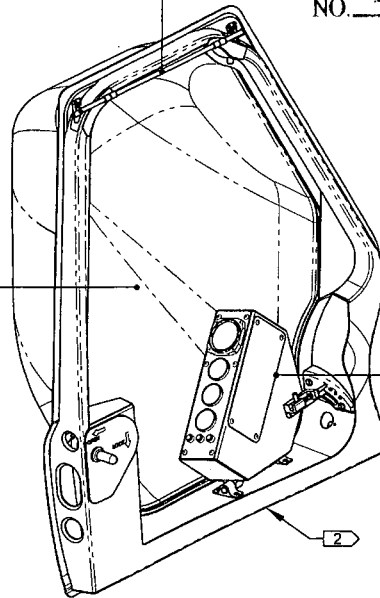
8 7 6 5 4 3 2 1



**D412-761-043 MODIFIED
LATCH MECHANISM KIT, LH** 3

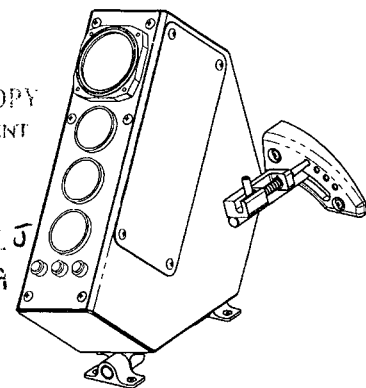


D412-761-045 LARGE BUBBLE WINDOW KIT, LH
DOUBLERS AND ANGLES NOT SHOWN FOR CLARITY 1



D412-761-041 FULL VERTICAL REFERENCE DOOR KIT, LH
D412-761-049 ARMREST KIT NOT SHOWN 5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75226
M.L.J.
11/10/19



D412-761-047 DOOR MOUNTED INSTRUMENT PANEL KIT
INSTRUMENTS NOT INCLUDED 4

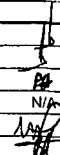
RELEASED
09/04/14

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. SHEPHERD (DE # 02)
DATE: 09.03.17
CERT. NO.: SH09-4
ISSUE NO.: 2

SHEET 1 NOTES:

- 1) SEE SHEETS 2, 3, 4, 5 AND 6 FOR MODIFICATION OF OEM DOOR WITH INSTALLATION OF D412-761-045 LARGE BUBBLE WINDOW KIT.
- 2) BELL APPROVED DOOR FOR HELICOPTER TYPE NOT INCLUDED IN D412-761-041 KIT. REFER TO OEM ILLUSTRATED PARTS CATALOG FOR ELIGIBLE PART NUMBERS.
- 3) SEE SHEET 7 FOR INSTALLATION OF D412-761-043 MODIFIED LATCH MECHANISM KIT.
- 4) SEE D412-761-2 DRAWING FOR INSTALLATION OF D412-761-047 DOOR MOUNTED INSTRUMENT PANEL KIT.
- 5) SEE D412-761-3 DRAWING FOR INSTALLATION OF D412-761-049 ARMREST KIT.

D	ELIMINATED RIB (SECTION A-A, ZN C4-2); UPDATED NOTE 5 SH 2, NOTES SH 4, ADDED ESCUTCHEON OPTION ON SH 6 TO ADDRESS COMPATIBILITY ISSUE. REASON: BASED ON FEEDBACK FROM EAGLE.	MB	09.03.17
C	TRANSFERRED SHEETS 8, 9 AND 10 TO D412-761-2 DRAWING. REASON: EASE OF USE	MB	08.12.10
B	REVISED SHEETS 1, 2, 3, 6, 7 AND 10	MB	08.07.11
A	NEW ISSUE	MB	08.05.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D412-761-1	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		FULL VERTICAL REFERENCE DOOR	NTS
DATE		09.03.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

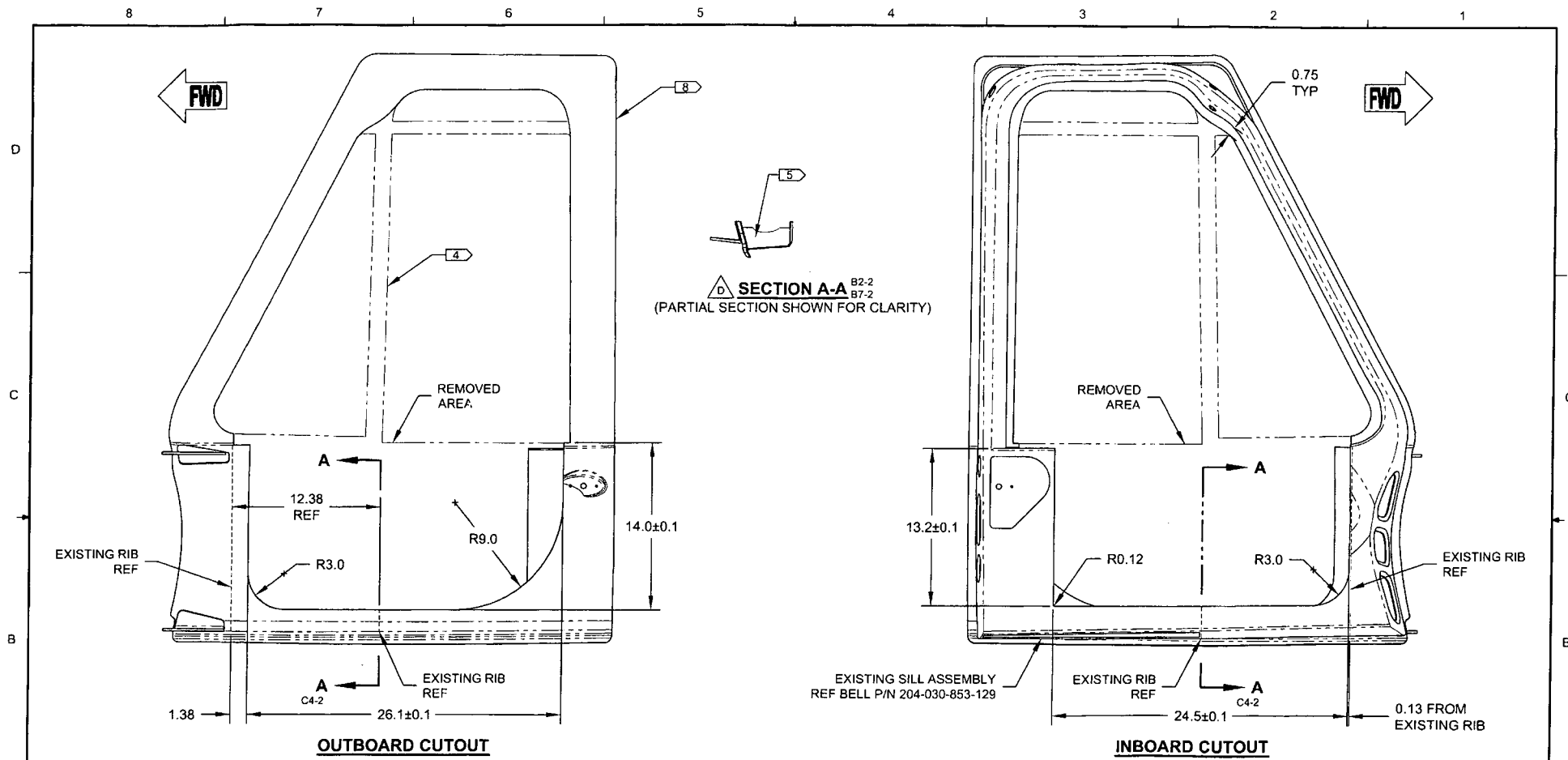
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SECTION A-A B2-2 B7-2
(PARTIAL SECTION SHOWN FOR CLARITY)

OUTBOARD CUTOUT

INBOARD CUTOUT

SHEET 2 NOTES:

OEM DOOR MODIFICATION: CUTOUTS

- 1) REMOVE, RETAIN AND INSPECT FOR DAMAGE EXISTING HANDLES, LATCH MECHANISM, SILL ASSEMBLY AND HARDWARE IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL.
- 2) DRAW CUTOUT ON DOOR AS SHOWN ABOVE. THE OUTBOARD CUTOUT IS LOCATED AT 1.38" FROM INDICATED FORWARD RIB AND THE INBOARD CUTOUT IS LOCATED 0.13" FROM THE SAME RIB.
- 3) LAY DOWN D3676-1 LARGE BUBBLE WINDOW ON TOP OF DOOR PER SHEET 6 TO ENSURE THAT THE CUTOUT WILL LEAVE ENOUGH EDGE DISTANCE ONCE THE WINDOW IS INSTALLED. RETRACE CUTOUT AS REQUIRED.
- 4) REMOVE VERTICAL MEMBER AND CUT THROUGH DOOR.
- 5) REMOVE EXISTING RIB.
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED
- 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8) BELL APPROVED DOOR FOR HELICOPTER TYPE. REFER TO ILLUSTRATED PARTS CATALOG FOR ELIGIBLE PART NUMBERS. MODIFY AS SHOWN.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-C-01

APPROVED
BY:
D. SHEPHERD (DE # 02)

DATE: 09.03.17
CERT. NO.: SH09-4
ISSUE NO.: 2

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D412-761-1	SHEET 2 OF 7
MFG. APPR.	N/A	TITLE	SCALE
APPROVED		FULL VERTICAL REFERENCE DOOR NTS	
DE APPR.			
DATE	09.03.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

RELEASED
09/24/14 MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

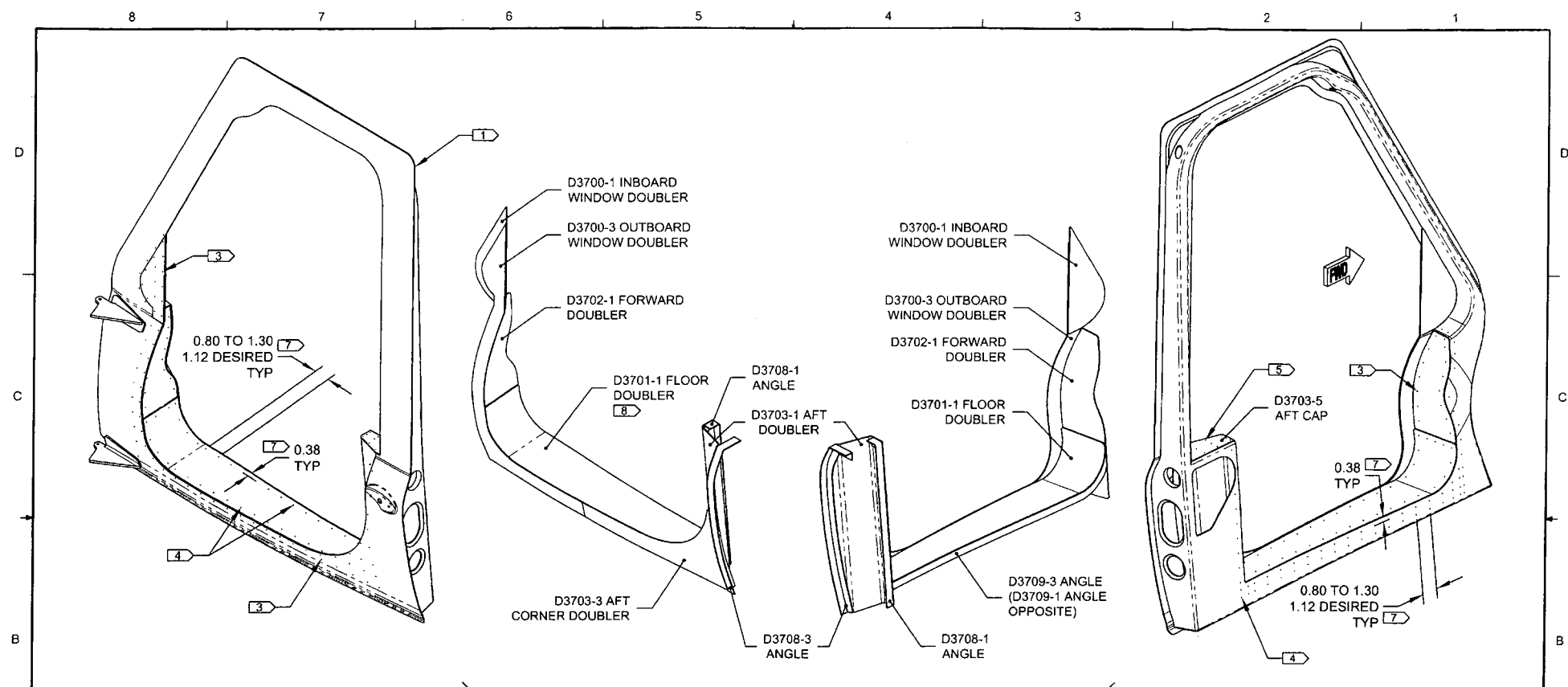
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75226



OEM DOOR MODIFICATION: LOCATION OF ANGLES AND DOUBLERS
MODIFIED OEM DOOR NOT SHOWN FOR CLARITY

SHEET 3 NOTES:

- 1) BELL APPROVED DOOR FOR HELICOPTER TYPE. REFER TO ILLUSTRATED PARTS CATALOG FOR ELIGIBLE PART NUMBERS. MODIFY PER SHEETS 3, 4 AND 5.
- 2) INSTALL DOUBLERS AND ANGLES USING CHERRYMAX RIVETS TO MODIFY BELL APPROVED DOOR FOR HELICOPTER TYPE.
- 3) USE CR3212-4 RIVETS TO FASTEN: A) D3700-1/-3, D3703-3, D3708-3 AND D3709-1 TO OUTBOARD DOOR SKIN, B) D3702-1 TO EXISTING RIB.
- 4) USE CR3213-4 RIVETS TO FASTEN: A) D3701-1 TO D3709-1/-3, B) D3703-1 TO D3708-1/-3, C) D3708-1, D3709-3 TO INBOARD DOOR SKIN.
- 5) USE CR3213-4 RIVETS TO FASTEN D3703-5 TO D3708-1/-3 AND EXISTING RIBS.
- 6) PICK UP ON EXISTING RIVET HOLES WHENEVER POSSIBLE. IT IS ACCEPTABLE TO USE OVERSIZED CHERRYMAX RIVETS (CR3242-4 AND CR3243-4) IN CASES WHERE THE EXISTING RIVET HOLES REQUIRE TO BE ENLARGED DUE TO WEAR AND TEAR.
- 7) INSTALL ALL RIVETS IN ACCORDANCE WITH AC43.13-1B, PARAGRAPH 4-58, AND FIG. 4-5 OR PER SECTION 3 OF BHT-MED-SRM-1.
- 8) DO NOT PERMANENTLY INSTALL D3701-1 FLOOR DOUBLER WITHOUT FIRST LOCATING THE POSITION OF D412-761-047 DOOR MOUNTED INSTRUMENT PANEL KIT. REFER TO SHEET 3 OF DRAWING D412-761-2 TO INSTALL THE MS21075L3 NUTPLATES (4 PL) ON THE UNEXPOSED SURFACE OF D3701-1. IF REQUIRED, IT IS ACCEPTABLE TO INSTALL MS21075L3 NUTPLATES ON D3709-1/-3 ANGLES.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # C2)

DATE: 09.03.17
CERT. NO.: SH09-4
ISSUE NO.: 1

RELEASED
09/04/17

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	N/A	D412-761-1	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FULL VERTICAL REFERENCE DOOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

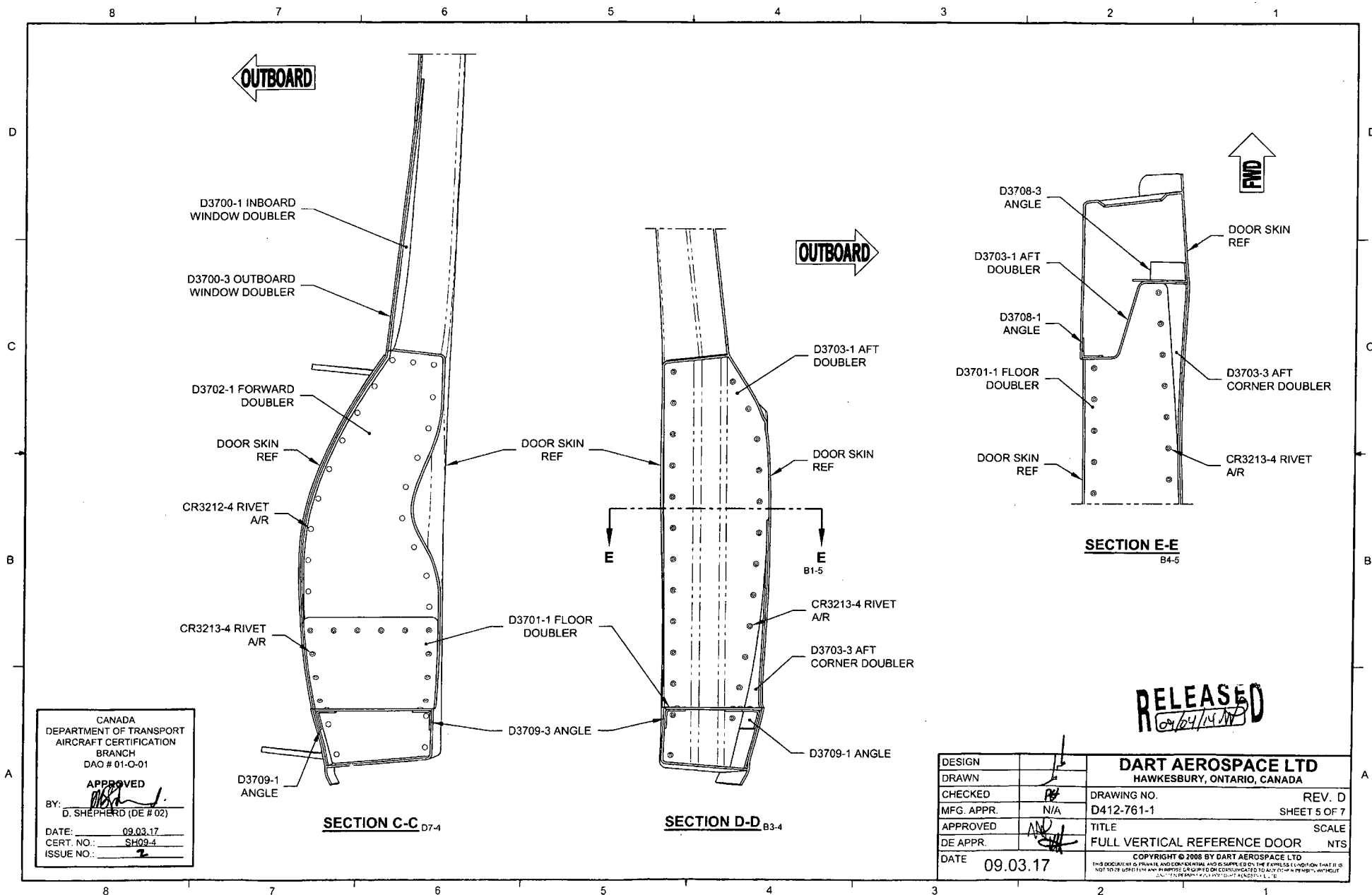
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75226



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	N/A	D412-761-1	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		FULL VERTICAL REFERENCE DOOR NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

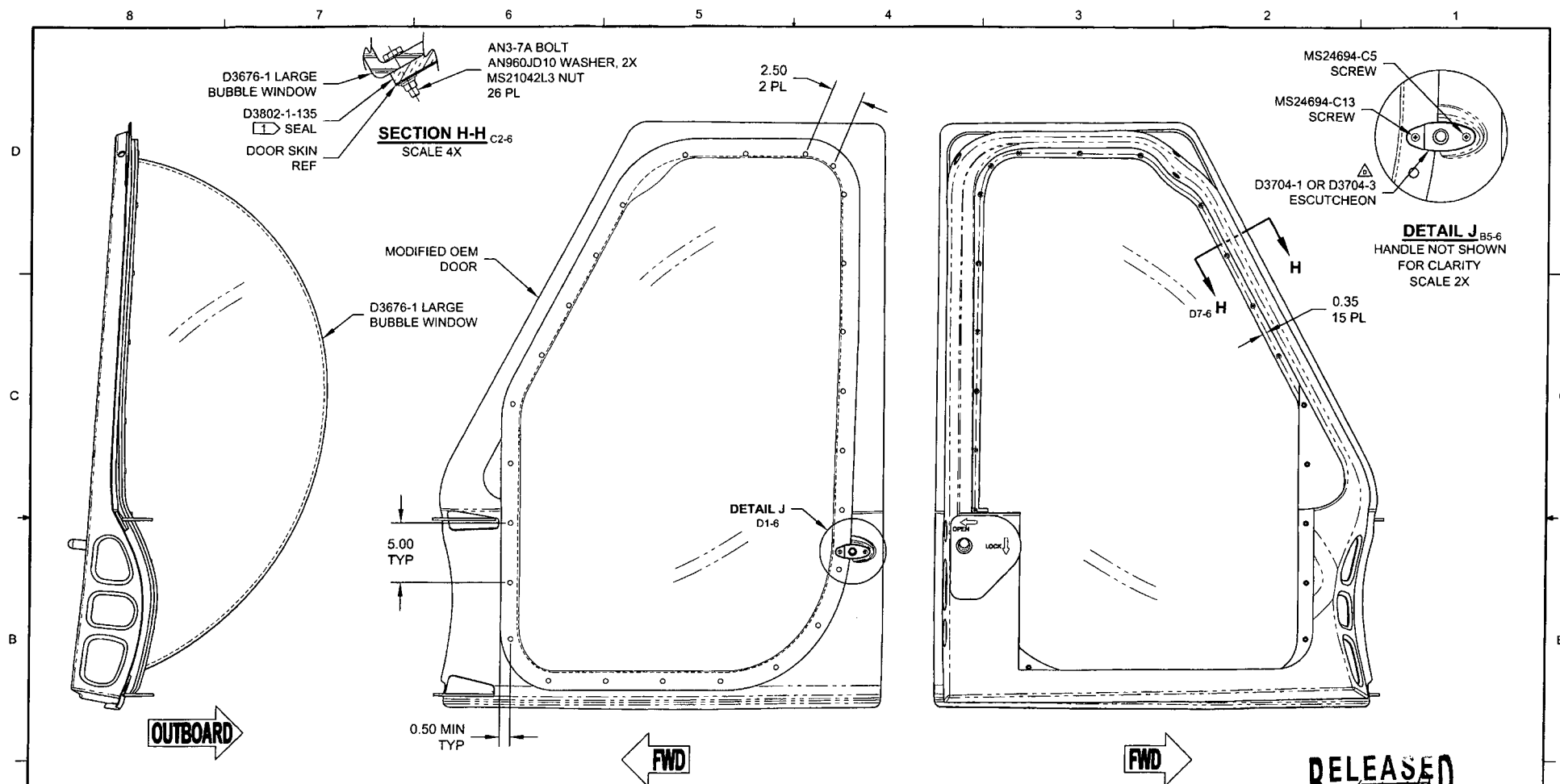
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75226



SHEET 6 NOTES:

- 1) INSTALL D3802-1-135 SEAL ON D3676-1 LARGE BUBBLE WINDOW.
- 2) LOCATE D3676-1 LARGE BUBBLE WINDOW AS SHOWN.
- 3) MARK BOLT PATTERN AS SHOWN. FOR THE LOWER PORTION OF THE BUBBLE WINDOW, THE MINIMUM EDGE DISTANCE ON THE FLANGE MUST BE 0.75" MIN FROM OUTSIDE EDGE. DETERMINE EDGE DISTANCE BASED ON THE CENTERLINE OF THE LIP, APPROXIMATELY 0.35" FROM INSIDE EDGE AS SHOWN FOR THE UPPER PORTION OF THE BUBBLE WINDOW.
- 4) DRILL Ø0.201 HOLES THROUGH DOOR OUTBOARD SKIN, AND PREVIOUSLY INSTALLED REINFORCEMENTS. FOR THE LOWER PORTION, DRILL FROM OUTBOARD TO INBOARD. FOR THE UPPER PORTION DRILL FROM INBOARD TO OUTBOARD.
- 5) TRANSFER DRILL Ø0.201 HOLES FROM MODIFIED OEM DOOR TO D3676-1 LARGE BUBBLE WINDOW.
- 6) LOCATE D3704-1 OR D3704-3 (COMPATIBLE WITH AAI HANDLE) ESCUTCHEON AND TRIM WINDOW FLANGE TO FIT. INSTALL ESCUTCHEON PER DETAIL J. TORQUE SCREWS TO 15 IN-LB (1.7 N-M) MAX.
- 7) INSTALL D3676-1 ON MODIFIED OEM DOOR PER SECTION H-H. TORQUE TO 15 IN-LB (1.7 N-M) MAX.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO #01-O-01	
APPROVED	
BY: D. SHEPHERD (DE # 02)	
DATE: 09.03.17	
CERT. NO.: SH09-4	
ISSUE NO.: 2	

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	AM	D412-761-1	SHEET 6 OF 7
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	AM	FULL VERTICAL REFERENCE DOOR NTS	
DE APPR.			
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RELEASED
09/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

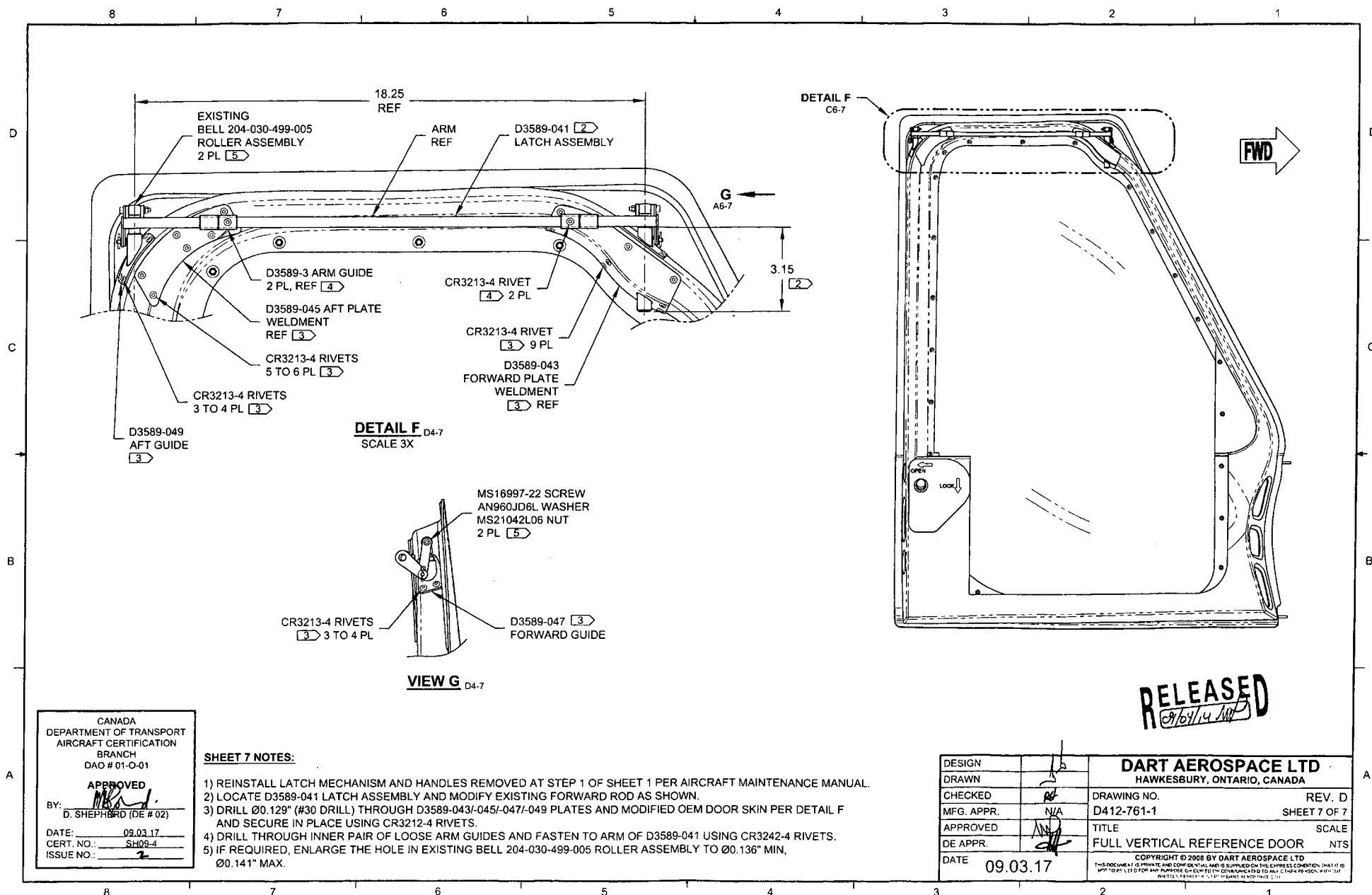
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75226



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

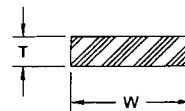
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

REFERENCE ONLY



D3802-X-YYY WINDOW SEAL WHERE YYY REPRESENTS LENGTH

DART P/N	SUPPLIER	SUPPLIER P/N	T' THICKNESS	W' WIDTH
D3802-1-YYY	McMASTER-CARR	93695K58	0.25	1.00

△C

EG: 0.25" X 1.00" X 40" WINDOW SEAL = D3802-1-400

RELEASED
2010-08-06
WHP

- NOTES:
- 1) MATERIAL: 'PEEL AND STICK' NEOPRENE/EPT/SBR BLEND CLOSED CELL SPONGE, MEDIUM DENSITY
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

C	CHANGE SUPPLIER P/N TO 93695K58 PER FLAMMABILITY TEST RESULTS	MB	10.06.30
B	CHANGE SUPPLIER P/N TO 93695K88 PER FLAMMABILITY TEST RESULTS	MB	08.12.16
A	NEW ISSUE	MB	08.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3802 SHEET 1 OF 1
TITLE SCALE
WINDOW SEAL NTS

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5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
		1			D3676-1	LARGE BUBBLE WINDOW
		1			D3678-1	PLACARD
		1			D3678-3	PLACARD
		1			D3700-1	INBOARD WINDOW DOUBLER
		1			D3700-3	OUTBOARD WINDOW DOUBLER
		1			D3701-1	FLOOR DOUBLER
		1			D3702-1	FORWARD DOUBLER
		1			D3703-1	AFT DOUBLER
		1			D3703-3	AFT CORNER DOUBLER
		1			D3703-5	AFT CAP
		1			D3704-1	ESCUTCHEON
		1			D3704-3	ESCUTCHEON
		1			D3708-1	ANGLE
		1			D3708-3	ANGLE
		1			D3709-1	ANGLE
		1			D3709-3	ANGLE
		1			D3802-1-135	SEAL
		1			DT9458	CUTTING TEMPLATE
		26			AN3-7A	BOLT
		52			AN960JD10	WASHER
		26			MS21042L3	NUT
		1			MS24694-C5	SCREW (OR MS24694-S5)
		1			MS24694-C13	SCREW (OR MS24694-S13)
			1		D3705-041	INSTRUMENT PANEL ASSEMBLY
			1		D3705-043	* INSTRUMENT PANEL WELDMENT
			1		D3335-1	* SPRING
			1		D3705-5	* ACCESS PANEL
			1		D3706-5	* PIN
			2		D3707-3	* MOUNTING LUG
			4		AN526C1032R6	* SCREW
			1		AN960JD516	* WASHER
			1		MS171498	* SPRING SLOTTED PIN
			4		MS24693-C272	* SCREW (OR MS24693-S272)

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			2		D3707-1	MOUNTING LUG
			1		D3790-1	INDEXING BLOCK
			1		D3867-1	CONNECTOR PLATE
			4		AN3-3A	BOLT
			6		AN526C1032R6	SCREW
			2		AN743-12	BRACKET
			6		AN960JD10L	WASHER
			6		MS21075L3	NUTPLATE (OR MS21073-3)
			4		MS24693-C272	SCREW (OR MS24693-S272)
			1		MS27039-1-17	SCREW
			1		MS27039-1-27	SCREW
			4		MS21042L3	NUT
			2		MS21919WDG8	CLAMP
				1	D3694-041	MOUNTING PLATE ASSEMBLY
				1	D3694-1	* KEYWAY
				1	D3694-3	* PROTECTIVE PLATE
				1	D3694-5	* MOUNTING PLATE
				1	AN526C1032R8	* SCREW
				5	AN960JD10	* WASHER
				4	MS21042L3	* NUT
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				4	MS24693-C273	* SCREW (OR MS24693-S273)
				1	D3695-041	SLIDER ASSEMBLY
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	D3780-041	ARMREST ASSEMBLY
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* LATERAL CUSHION ASSEMBLY
				1	D3781-043	* ARMREST CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				1	D3977-1	* BOLT
				1	D3978-1	* NUT (CASTELLATED)
				1	D3979-1	* WASHER (SQUARE HOLE)
				2	AN970-6	* WASHER
				1	MS24665-302	* COTTER PIN
				2	MS21042L3	* NUT
				2	MS24693-C272	* SCREW
				2	MS24693-C277	* SCREW
				1	NAS1149D0663J	* WASHER

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 10)

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Revision: D

Date: 09.06.18

(CONTINUED FROM PAGE 9)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
				11	AN3-6A	BOLT
				1	AN6-26	BOLT
				1	AN310-6	CASTELLATED NUT
				11	AN960JD10	WASHER
				1	AN960JD616L	WASHER
				2	NAS1515H6L	WASHER
				1	MS24665-302	COTTER PIN
				3	MS21071L3	ANCHORNUT
				8	MS21075L3	NUTPLATE

6.0 PARTS LIST, OPTIONAL VENT KIT

QTY -141	PART NUMBER	DESCRIPTION
X	D412-761-141	VENT KIT
4	D3932-1	SNAP VENT